Work Orde Friday, August 1												Page 1
Revision ID: Item Name:	D3236-1 Window 8/19/2011 8/26/2011	Start Qty: 4.00 Req'd Qty: 4.00		Accept	Cust Item I Customer:]]	Setup	Start Stop		
Approvals:	Process Pla	in: MF	Date: //-/08-/	-		nte:]	Run	Start Stop		
Sequence ID/ Work Center ID)	Operation Description		Set Up/ Run Hours	Tool ID			ccept	Rejo Qty		Reject Number	Insp. Stamp
Draw Nbr D3236	Rev	ision Nbr B										
100 Waterjet FLOW CNC Waterje	t	FLOW WATER JET Memo Cut as per I	Dwg D3236 □Dwg Rev	0.00 . 0.00 :	11/08/22 B			4				
110 QC Quality Control		QC2- Inspect parts off m	achine FAI/FAIB	0.00	11/08/22			4				
120 QC		QC8- Inspect parts - seco	and check	0.00 Su	closter		(44	_)			

Quality Control

Work Order ID 72947

Friday, August 19, 2011 1:46:23 PM



Page 2

Item ID:

D3236-1

Accept



Setup Start

Stop



Revision ID:

Item Name:

Window

Start Date: 8/19/2011 **Required Date: 8/26/2011** Start Qty: 4.00

Req'd Qty: 4.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:____

Tooling:

Date:

Run

Start

Stop



QC:

Date: _____

SPC (Y/N):

Set Up/

Run Hours

Date:

Tool ID

Tool # Plan Accept

Qty

Code

Reject Qty

Reject Number

Insp. Stamp

130

Sequence ID/

Work Center ID

Small Fab Small Fab

Small Fab

Operation

Description

Memo

0.00

0.00

Deburr Engrave Part Number & Batch Number as per Dwg D3236

140

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Sul08/22

Identify as per dwg & Stock Location

0.00

Packaging

Memo

Memo

0.00

Packaging

150

Work Order ID 72947

Friday, August 19, 2011 1:46:23 PM



Page 3

Item ID:

D3236-1



Setup Start

Stop



Revision ID:

Item Name:

Window

8/19/2011 **Start Date: Required Date: 8/26/2011**

Start Qty: 4.00 Req'd Qty: 4.00

Date: _____

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

QC:

Date:

Tooling:

SPC (Y/N):

Accept

Date:

Run

Start

Stop



Sequence ID/

Work Center ID

160

Operation Description

QC21- Final Inspection - Work Order Release

Set Up/ **Run Hours**

Tool ID

Date:

Tool # Plan Code

Reject Accept Qty Qty

Reject Number

Insp. Stamp

Memo

0.00

0.00

Quality Control

Picklist Print

Friday, August 19, 2011 1:46:21 PM

Work Order ID: 72947

Parent Item: D3236-1

Parent Item Name: Window

Start Date: 8/19/2011

Required Date: 8/26/2011

Page 1

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP rev. A 06.03.07 New Issue

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MACRLICS.125		Purchased	No	· · · · · · · · · · · · · · · · · · ·		110	sf	241.4934	1.955	8.231579			

1/8" Polycast II Sheet

Location	Loc Qty	Loc Code	
MAT	142.2467		
(117431)	142.2467		8.4 \$ 11/08/22
MAT018	96.2467		
117324	43.7667		
117340	52.48		<u></u>
MAT019	3		
115338	3		

DART AEROSPACE LTD	Work Order:	7247
Description: Window	Part Number:	D3236-1
Inspection Dwg: D3236 Rev: B		Page 1 of 1

	FIRST ARTICLE INSPECTION CHECKLIST									
		x	First Artic	ele 🗌	Prote	otype				
	rawing nension	Tolerance	Actual Dimension	Accept	Reject	Method Inspecti		omments		
	11.84	+/-0.030	11.84			PAO	1 TA	DE		
	23.03	+/-0.030	23.03		_	4	cı			
,						- ,				
						-				

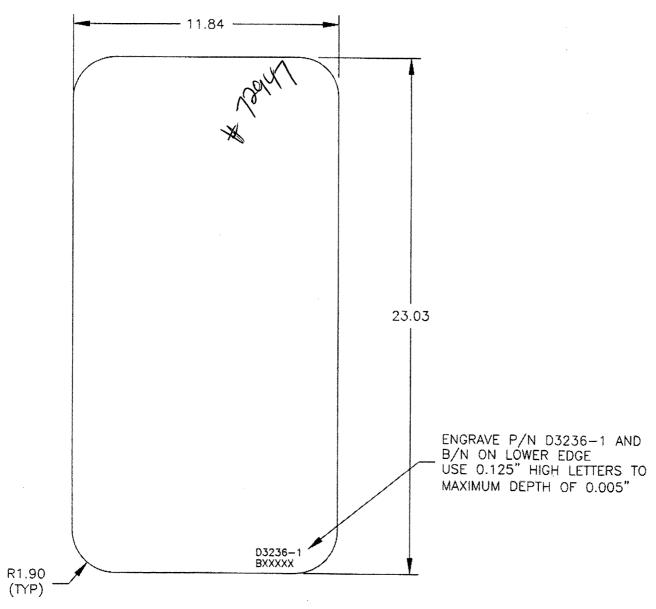
				-						
Meas	ured by:		Audited by:	9		Prototype	Approval:	N/A		
	Date:	1/08/22	Date:	11/05/2-			Date:	N/A		
Rev	Date	Change			-		Revised by	Approyed		
Α	04.06.25	New Issue	P/O D412-709	9-015/-017			KJ/JLM 🛪	- (11)		





	DESIGN	DRAWN BX		ROSPACE LTD
	CHECKED	APPROVED.	DRAWING NO.	REV. B
i	TIN	#	D3236	SHEET 1 OF 1
	DATE		TITLE	SCALE
	04.05.05		WINDOW	NTS
- 1	1			

Α	03.12.18	NEW	ISSUE			***************************************	-
В	04.05.05	ADD	THICKNESS	&	ENGRAVING	SPEC	-



D3236-1 WINDOW

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 0.125" THICK (REF DART SPEC. M-ACRYLIC-S.125)
- 2) TOLERANCÈS ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

3) ALL DIMENSIONS ARE IN INCHES

Copyright © 2003 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.